Quality Control

Thursday, July	22, 2010 1:01:52 PM												Page 1
Item ID: Revision ID:	D4148-1 -PRELIM M				Accept					Setup	Start		
Item Name:	Crosstube Lug Plate, F	wd									Stop		
Start Date: Required Date: Reference:		Qty: 8.00 Qty: 8.00	·		ı	Cust Ite Custom							•10 110 1101
Approvals:	Process Plan:	H		1-7-22	Tooling:	3	Date:		1	Run	Start Stop	( (884HB) B)	
	QC:		_ Date:		SPC (Y/N):		Date:	· · · · · · · · · · · · · · · · · · ·			•		
Sequence ID/ Work Center I	Opera D Descri				Set Up/ Run Hours	Tool I	D Too	l# Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision NI	or						1					
D4148	PATB	10.0	7.22										
100 Waterjet		Memo			0.00	, s 1	•		m	/ 	10	07	23 8
FLOW CNC Water	jet	Cut as per of Prog Rev:	Ř				. 5	n (d) =	17/27			(2	
•		Deburr as re	equired		<b>.</b>								
	QC2- In	spect parts off n	nachine FAI/F	AIB	0.00	,			$\Lambda_{\alpha\alpha}$	,			<u> </u>
QC		Memo			0.00				144 (	_10	١	07	33(8

## **Dart Aerospace Ltd**

W/O:			V	VORK ORDER CH	ANGES						
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Cty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								-			
									-		
Part No:PAR		PAR #:	Fault Ca	Fault Category: NCR: Yes No DQA:					Date: _		
Resolution:		Disposit	ion:	Q <i>A</i>	: N/C CI	osed:	ed: Date: _				
NCR:			WORK OR	DER NON-CONFO	RMANC	E (NCR	l)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B	Sign &	Verifica Section	tion	Approval Chief Eng	Approval QC Inspector	
			Criter Eng	Chief Eng	***************************************	Date					
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AMP -				,	,						
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NOTE: Date & initial all entries

<b>Work Order ID</b>	6077
Thursday, July 22, 201	0 1:01:52



Page 2

Item ID:

D4148-1

**Revision ID:** 

**PRELIM** 

Item Name:

Crosstube Lug Plate, Fwd

**Start Date:** 

7/22/2010

Start Qty: 8.00

PM

Required Date: 7/29/2010

Req'd Qty: 8.00



Accept

Setup Start

Stop



**Cust Item ID:** 

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date:\_\_\_\_\_

Tooling:

Run

Start



QC: \_

Date: SPC (Y/N):

Date:

Date:

Stop

Sequence ID/ **Work Center ID** 

120

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/

**Run Hours** 

0.00

Tool ID

Tool # Plan Accept Code Qty

Qty

Reject Reject

Insp. Number Stamp

150

Packaging

Packaging

Identify as per dwg & Stock Location: 3

B 60774

0.00

0.00

So 10/07/27

160

Quality Control

QC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

10/07/28 HJ

Dart Aerospace	• Ltd
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W/O:			V	ORK ORDER CHAN	NGES					irl an
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Cty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					-					
Part No: PAR #:			Fault Ca	tegory:	NCF	R: Yes N	lo DQA:		Date:	
	R	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date:	
NCR:		V	VORK OR	DER NON-CONFOR	MANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action  Action Description  Chief Eng	Section B	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
			Office Erig	Cillel Eng		Date				
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NOTE: Date & initial all entries

## **Picklist Print**

Thursday, July 22, 2010 1:01:56 PM

Work Order ID: 60777

Parent Item: D4148-1

Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 7/22/2010

Required Date: 7/29/2010

Page 1

Required Qty: 8.00

Start Qty: 8.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	105.2383	0.3607	3.037474			
304/316 0.125 Sheet							}					· · · · · · · · · · · · · · · · · · ·	
				Location		Loc C	<u>Oty</u>	Loc Code			m	10.07	12
				MAT		105.2	2383				7747	10.07.	23
					114488	1.5	5259 i						
					114799	103.7	7124		_				

## **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANG	ES					V ,
DATE	STEP	PRO	CEDURE CH	ANGE	E	у	Date (	ty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						_				
						:				
		,							·	
		Fault Cate	egory:	_ NCR:	Yes N	lo DQA:	Date:			
Part No: PAR #: Fault Category:  Resolution: Disposition:  NCR: WORK ORDER NON-CONFORMA		_ QA: N	C Clo	sed:		Date: _				
NCR:		V	ORK ORE	DER NON-CONFORMA	ANCE (	VCR)				
DATE	0750	Description of NC Corrective Action Section B					Verificat	on	Approval	Approval
DATE	DATE STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng				Section C	Chief Eng	QC Inspector
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		·								-
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				·						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	60777
Description: CROSSTUBE Lug Plate, FWD	Part Number:	D4148-1
Inspection Dwg: 식)식용-  Rev: R		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
\$0.191	+0.005-0.001		1		very	MM-01
00.129	+0.005-0.001	0.132	$\sqrt{}$	k	NOW	
00.50	100.6-806.6+	0.500	$\checkmark$		VWN	
\$0.257	+0.006-0.001	0.257			VWN	
Ø0.38	+0.006-0.001	0.379	$\bigvee$		VWN	
0.625	+/-0.010	0.63	<b>V</b>		VEVN	
1.000	+1-0.010	1.004	V		VEN	
0.500	41-0.010	0.501	· V		VEVN	
1.54	+1-0.030	1.54	<u> </u>		Vern	
2.47	+1-0.030	2.471	<b>√</b>		VIVN	
Ø0.191	+0.005-0.001	0.196	<u> </u>		VIV	
0.310	+1-0.010	0.313	<b>✓</b>		Vern	·
0.750	+1-0.010	0.754	<b>V</b>		VWV	
1.98	+1-0.030	1.977	<b>√</b>		MMA	
1.84	41-0.030	1.836	<b>√</b>		MM	
0.375	+1-0.010	0.378	<b>V</b>		VEN	
4.730	+1.0.010	4.733			VWN	
1.23	+1-0.030	1.93	✓ .		Very	
3.57	41-0.030	3.581	<b>V</b>		VWV	
	data semana and a semana a semana a semana a				-	9,
		*				
			-			

I	Measured by:	ml.ml	Audited by:	Prototype Approval:	N/A
	Date:	10.07.23	Date: 10/07/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

